Date: Thursday, 9/14/2006 4:32:36 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28602
Estimate Number : 10523
P.O. Number : N/A
This Issue : 9/14/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : MACHINED PARTS
Previous Run : 28255
Written By :
Checked & Approved By : 06 09 14
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC

Drawing Name : SADDLE, OUTBOARD, RH, 206
Part Number : D26652
Drawing Number : D2665 REV. C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 9/30/2006 **Qty:** 8 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length B25347

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
1- Program batch number
2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
5- Deburr JL/SA 06.09.20 8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet JL 06/09/22 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL/SA 06.09.20 8

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK MB 06/09/22 8

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
06.09.24	7	FOR DIMENSION '5', the Ø0.313 saddle-to-crosstube holes, it is acceptable to drill Ø 0.316. See attached DS email				GP 06.09.24 per QSI 042	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ~~DD~~ **Date:** 06/09/24

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 4:32:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE, OUTBOARD, RH, 206

Job Number: 28602 **Part Number:** D26652

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	SAD 06:09:24
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	a.m 06-09-25
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	06/9/26
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST483	06/09/26
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	06/09/26

Job Completion

06-09-26

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28602
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.121	.120	.121		
B	0.100	0.140		.125	.122	.119	.119		
C	1.125	1.145		1.134	1.130	1.133	1.136		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.252	.253	.248	.248		
F	1.313	1.343		1.326	1.327	1.327	1.329		
G	0.210	0.230		.222	.220	.219	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.492	2.493	2.493	2.493		
J	1.565	1.585		1.572	1.569	1.571	1.574		
K	0.235	0.240		.236	.237	.236	.236		
L	0.100	0.120		.120	.120	.119	.120		
M	0.990	1.010		1.002	1.001	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.000	6.000	6.001		
P	1.245	1.255		1.256	1.250	1.250	1.249		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.500	2.499	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.796		
W	0.540	0.560		.550	.550	.551	.551		
X	1.674	1.684		1.679	1.679	1.678	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.922	.922	.922	.922		
AA	0.490	0.510		.498	.501	.499	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA / JL
Date:	06/09/22

Audited by	MS
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	28602
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.122	.122		
B	0.100	0.140		.119	.119	.120	.121		
C	1.125	1.145		1.136	1.133	1.136	1.136		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.250	.251	.251	.250		
F	1.313	1.343		1.327	1.328	1.327	1.327		
G	0.210	0.230		.221	.220	.221	.221		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.493	2.493	2.493	2.493		
J	1.565	1.585		1.574	1.573	1.574	1.573		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.120	.120	.120	.120		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.001	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.499		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.501		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.799	.800	.800	.798		
W	0.540	0.560		.551	.552	.550	.551		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.922	.920	.920	.919		
AA	0.490	0.510		.500	.501	.501	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	06/09/21

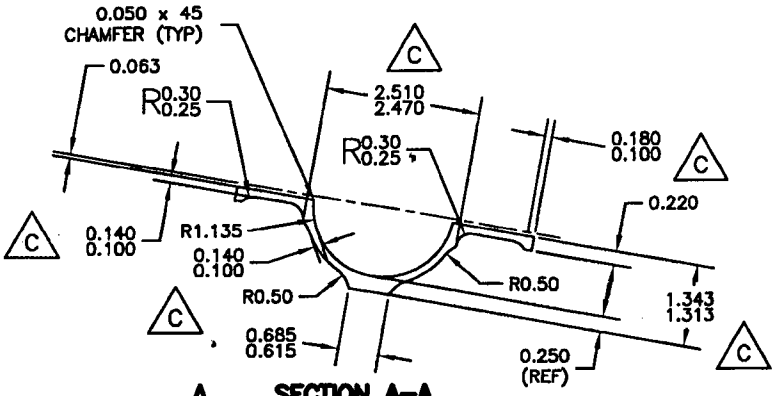
Audited by	MS
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

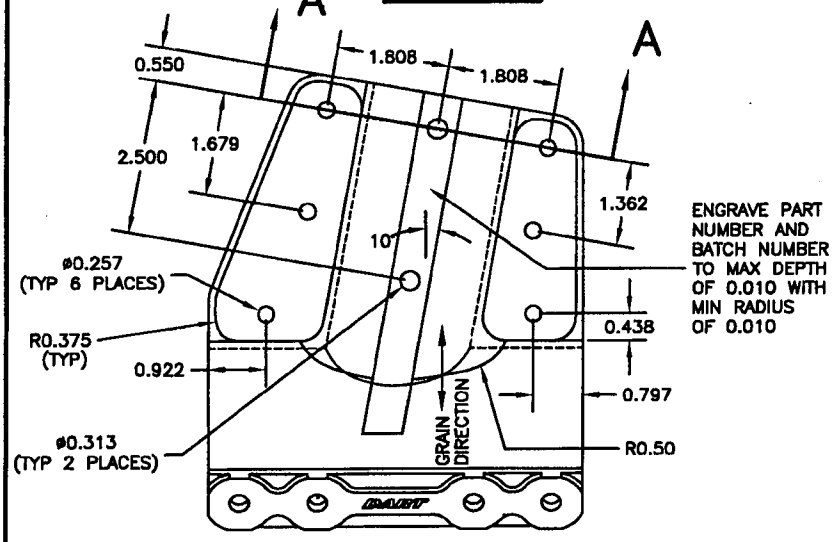
DESIGN		DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED		APPROVED	DRAWING NO. D2665 REV. C SHEET 1 OF 1
DATE 06.05.29			TITLE SADDLE FWD OUTSIDE HIGH SCALE 1:3

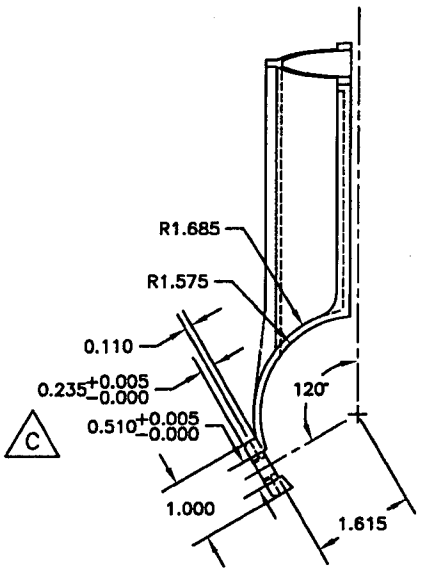
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095

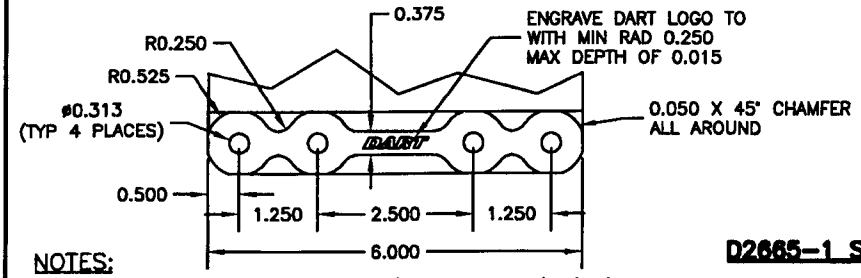
RELEASED 06.06.28



SECTION A–A







D2665–1 SADDLE FWD OUTSIDE HIGH

NOTES:

1) MATERIAL: 7075–T7351 (QQ–A–250/12) (REF DART SPEC M7075T73B)
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
   POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1 C
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) D2665–1 SHOWN (D2665–2 IS OPPOSITE)
6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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WORK ORDER NO. 28602

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 21, 2006 2:58 PM
To: 'Chris Provencal'
Cc: 'C Bell'; 'S Shahbazian'
Subject: RE: D2665 Saddle

This is acceptable.
For some reason, I thought someone was in the process of fixing these drawings (Chris Bell?)
In fact, I may have already signed them.
Please look into it.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, September 21, 2006 7:26 AM
To: David Shepherd (David Shepherd)
Subject: D2665 Saddle

David,

The two 0.313 OD saddle-to-crosstube holes, the dwg says 0.313, the folio is evidently calling for a 0.316 drill. The 0.316 is required to fit the part on the tooling, they must have been using 0.316 for some time. Anyhow, they want the drawing changed to 0.316 (I don't see a big problem with that), but for now they need an email to sign of this latest batch as a deviation on the work order. Ultimately this would affect all the 206 saddles. Is 0.316 OD acceptable for the saddle-to-crosstube holes on the D2665 saddles?

Chris